

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011178**Date Inspected:** 04-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Ying Xin, Tu Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10 TOWER STRUT

This QA inspector performed Ultrasonic Testing (UT) of approximately 10%, Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT and MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

ED1-A6003-4 GREEN TAG NO. 11692

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 10

TOWER STRUT

SMAW welding of weld joint 45 located on ND1-STSA3-1-89M-1.

Welder is identified as 053049. ZPMC CWI is identified as Mr. Chen Ying Xin.

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The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

SMAW welding of weld joint 35 located on ND1-STSA3-1-109M-1.

Welder is identified as 056364. ZPMC CWI is identified as Mr. Chen Ying Xin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

NORTH TOWER LIFT 4 SKIN A/B CORNER SEAM REPAIR

SMAW welding of weld joint 4A/B (Repair) located on NSTL4-3B/L.

Welder is identified as 056200. ZPMC CWI is identified as Mr. Tu Jun.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-REPAIR.

NORTH TOWER LIFT 4 SKIN C/D CORNER SEAM REPAIR

FCAW welding of weld joint 1A/B (Repair) located on NSTL4-3B/L.

Welder is identified as 040261. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-2G(2F)-REPAIR.

During random in process observations this Caltrans Quality Assurance (QA) Inspector observed that ZPMC personnel performing production welding without a ZPMC Quality Control (QC) Inspector present for a time period exceeding 30 minutes. This QA Inspector was present from 07:50 to 08:40 hours. This time frame exceeds the allowable maximum time of 30 minutes for QC Inspection coverage as required by Caltrans Special Provision Section 8-3.01. The welder is identified as, welder # 215620. The Flux Cored Arc Welding (FCAW) process was being performed on the Grating Brackets at 56M elevation diaphragm of North Tower lift 2. These components are all located inside the Tower bay 10. This issue has an incident report.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

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| Inspected By: | Gaikwad,Umesh | Quality Assurance Inspector |
| Reviewed By: | Clifford,William | QA Reviewer |
